

Work Order ID 62983

Thursday, October 14, 2010 3:07:16 PM



Page 1

Item ID: D3684-049

Accept



Setup Start



Revision ID:

Stop



Item Name: AFT LEG ASS'Y

Start Date: 10/15/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: 10-10-14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3684

Rev. D

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684

2-Assemble D3693-1 & D3691-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684

***Ensure holes for AN3C Bolts are free of sealant.
Torque Fastners as per Dwg D3684*ES 10/10/15* (Signature)*ES 10/10/15* (Signature)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

SP 10/10/15

(4)

Memo

0.00

130



Packaging

Packaging

Identify as per dwg & Stock Location: 078

0.00

Memo

0.00

C. P. 10/14/18 (4)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/10/19
MTF
10-10-18

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Picklist Print

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Work Order ID: 62983

Parent Item: D3684-049

Parent Item Name: AFT LEG ASS'Y



Start Date: 10/15/2010

Required Date: 10/22/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A new issue 08-02-12 DD verified by:JLM
 IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC
 REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC
 IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C12A Bolts		Purchased	No			110	Each	38.0000	2	8		10/10/15	
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
				ST351				38					
				112314				8					
				114761				11					
				115392				4					
				115594				15					
D3688-3 STUD		Manufactured	No			110	Each	6.0000	1	4		10/10/15	
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
				ST076				5					
				61371				5					
				ST080				1					
				51297				1					
D3689-1 SLEEVE		Manufactured	No			110	Each	4.0000	1	4		10/10/15	
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
				ST76				4					
				62188				4					

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Parent Item: D3684-049

Parent Item Name: AFT LEG ASS'Y

Start Date: 10/15/2010

Required Date: 10/22/2010

Start Qty: 4.00

Required Qty: 4.00

D3691-1
STUD
Manufactured No

110 Each

23.0000

1

4

Location

Loc Qty

Loc Code

ST077

16

61370

16

ST082

7

58631

7

D3692-1
SPACER
Manufactured No

110 Each

281.0000

4

16

Location

Loc Qty

Loc Code

ST082

281

51467

281

D3693-1
Rod End Bearing
Manufactured No

110 Each

32.0000

1

4

Location

Loc Qty

Loc Code

ST082

32

50734

32

MS21043-3
Nut
Purchased No

110 Each

2,548.000

2

8

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

2472

111383

23

112314

2449

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Shop Packet Print

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Start Date: 10/15/2010

Required Date: 10/22/2010

Start Qty: 4.00

Required Qty: 4.00

NAS509-12C

Purchased

No

110

Each

38.0000

1

4



Nuts

Location

Loc Qty

Loc Code

ST280

38

112453

38

NAS509L12C

Purchased

No

110

Each

43.0000

1

4



Nuts

Location

Loc Qty

Loc Code

ST280

43

112314

33

112828

10

4

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Shop Packet Print

Page 3

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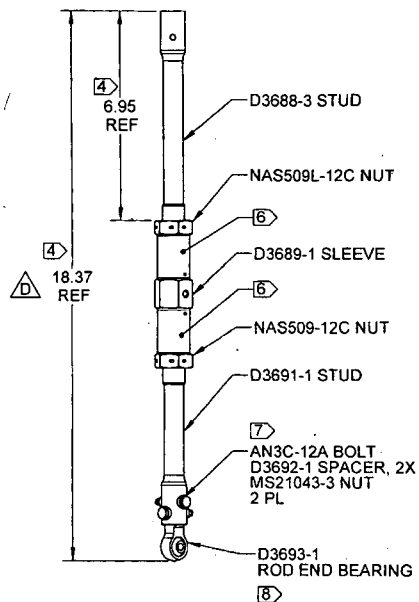
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ITEM	QTY 049	PART NUMBER	DESCRIPTION
1	X	D3684-049	AFT LEG ASSEMBLY
2	1	D3688-3	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT



D3684-049 AFT LEG ASSEMBLY

RELEASED
2010-03-15

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSION SHOWN IS WHEN D3688-3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 2.86 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D3684	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	TRIPOD MOUNT ASSY	NTS
DATE	10.03.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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